

Date: Thursday, 11/15/2007 1:23:34 PM  
 User: Kim Johnston

## Process Sheet

|                       |  |                  |                              |
|-----------------------|--|------------------|------------------------------|
| Customer              | : CU-DAR001 Dart Helicopters Services  | Drawing Name     | : FWD TUBE ASSEMBLY          |
| Job Number            | : 35762  |                  |                              |
| Estimate Number       | : 10467  |                  |                              |
| P.O. Number           | : <i>N/A</i>   | Part Number      | : D3391021                   |
| This Issue            | : 11/15/2007 S.O. No. : <i>PLA</i>   | Drawing Number   | : D3391 REV G                |
| Prsht Rev.            | : <i>NC</i>  | Project Number   | : <i>N/A</i>                 |
| First Issue           | : <i>N/A</i> Type : MACHINED PARTS   | Drawing Revision | : <i>G</i>                   |
| Previous Run          | : 35761  | Material         | : <i>N/A</i>                 |
| Written By            | : <i>[Signature]</i>   | Due Date         | : 12/10/2007 Qty: 1 Um: Each |
| Checked & Approved By | : <i>[Signature]</i>   |                  |                              |
| Comment               | Est. A 05.09.13 New issue KJ/JLM<br>Est. B 06.02.10 Dwg rev.D ecn 773 EC<br>Est. C 06.05.02 Added inspections EC<br>est D 07.03.13 rev F dwg EC<br>est E 07.11.07 revG dwg ecn1053P EC verified by: DD<br>Est Rev:f ECN 1056 07-11-12 DD verified by: EC |                  |                              |

## Additional Product

Job Number:



|         |                       |               |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

|     |          |                |
|-----|----------|----------------|
| 1.0 | D6013047 | SKIDTUBE MAT'L |
|-----|----------|----------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

SKIDTUBE MAT'L

Pick:

|     |             |             |                          |
|-----|-------------|-------------|--------------------------|
| Qty | Part Number | Description | Batch                    |
| 1   | D6013-047   | Extrusion   | <i>B26547 DP 7-11-19</i> |

|     |                |                         |
|-----|----------------|-------------------------|
| 2.0 | LANDING GEAR 1 | LANDING GEAR RESOURCE 1 |
|-----|----------------|-------------------------|



Comment: LANDING GEAR RESOURCE 1

Cut extrusion to 46.52 +0.010 -0.020

*DP 7-11-19*

|     |         |                 |
|-----|---------|-----------------|
| 3.0 | BENDING | BENDING MACHINE |
|-----|---------|-----------------|



Comment: Nc bender

Bend as per Dwg D3391 Using Bend Prog 3391021

*EL 7-11-26*

|     |     |                              |
|-----|-----|------------------------------|
| 4.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|-----|-----|------------------------------|



Comment: INSPECT WORK TO CURRENT STEP

*G AUL26 @*

|     |       |                                |
|-----|-------|--------------------------------|
| 5.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 |
|-----|-------|--------------------------------|



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA590 Rev. *F* & Dwg D3391 Rev. *G*

Identify as D3391-1

*SA 07.12.04*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Thursday, 11/15/2007 1:23:34 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD TUBE ASSEMBLY

Job Number: 35762

Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Deburr

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SD 07.12.04

7.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE  
Drill X1 Aft cap as per Dwg D3391

07.12.04 ①

8.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

07.12.04 ①

9.0

QC8

SECOND CHECK



Comment: SECOND CHECK

07.12.04 ①

10.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill float bag holes as per Dwg D3391 using DT8798(Do not open tow cap holes to finish size)  
(ONLY DRILL HOLES MARKED "A")

2-Drill Remaining two holes for tow cap using DT 8819 Locating off of .1875" holes drilled in previous step

3-Open tow cap holes to .208" as per Dwg D3391

4-Open Tow Ring hole to .640" as per Dwg D3391

5-Deburr & Scribe Batch number Inside aft end.

7-12-4

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.12.04 ②

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Thursday, 11/15/2007 1:23:34 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD TUBE ASSEMBLY

Job Number: 35762

Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description:

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

DP 7-12-4

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BE 7-12-4

14.0

D36704200

SPACER



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

SPACER

batch: B35813

DP 7-12-4

15.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

instal spacers as per dwg D3391

exp- 8-4-1

A/R Magnabond 6398 batch:

M105329

DP 7-12-4

(2PM)

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

f Al205

@ 4:00pm

17.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 105914

PR 07-12-14

①

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PR 07/12/17 ①

19.0

AELS1032130

INSERT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

INSERT

batch: M05729

PR 07/12/17 ①

\*

# Dart Aerospace Ltd

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Thursday, 11/15/2007 1:23:34 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD TUBE ASSEMBLY

Job Number: 35762

Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

AELS1032225

INSERT



\*

Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

INSERT

batch: *m/100489*

*FL*

21.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install Inserts as per Dwg

*FL 07/12/17 ①*

22.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*5 07/12/17 ②*

23.0

D3401041

Tow Cap Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Tow Cap Assembly

Pick:

Qty

Part Number

Description

Batch

1

D3401-041

Tow Cap

*B24887*

*m. h. FL*

24.0

D356413

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

*B33456*

*m. h. FL*

25.0

D356613

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

*B32744*

*m. h. FL*

26.0

D36721

PHENOLIC WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

PHENOLIC WASHER

*B34470*

*m. h. FL 07/12/17 ③*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: A Date: 08/01/16  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries



Date: Thursday, 11/15/2007 1:23:34 PM

User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD TUBE ASSEMBLY

Job Number: 35762

Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

AN3C4A

BOLT



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bolt

Pick:

Qty

Part Number

Description

Batch

4

AN3C4A

Bolt

M106431

M. H. / FL

28.0

AN960C10L

washer



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

washer

M106302

M. H. / FL

29.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

Install tow Cap as per Dwg D3391

Identify as D3391-021

FL 07/12/17 (1)

30.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inspect thread of each insert using DT8821

inspect to current step

31.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

P/N 35748 C 8/1/17

32.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(1)  
D 08/01/16

Job Completion



u 08/01/16

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

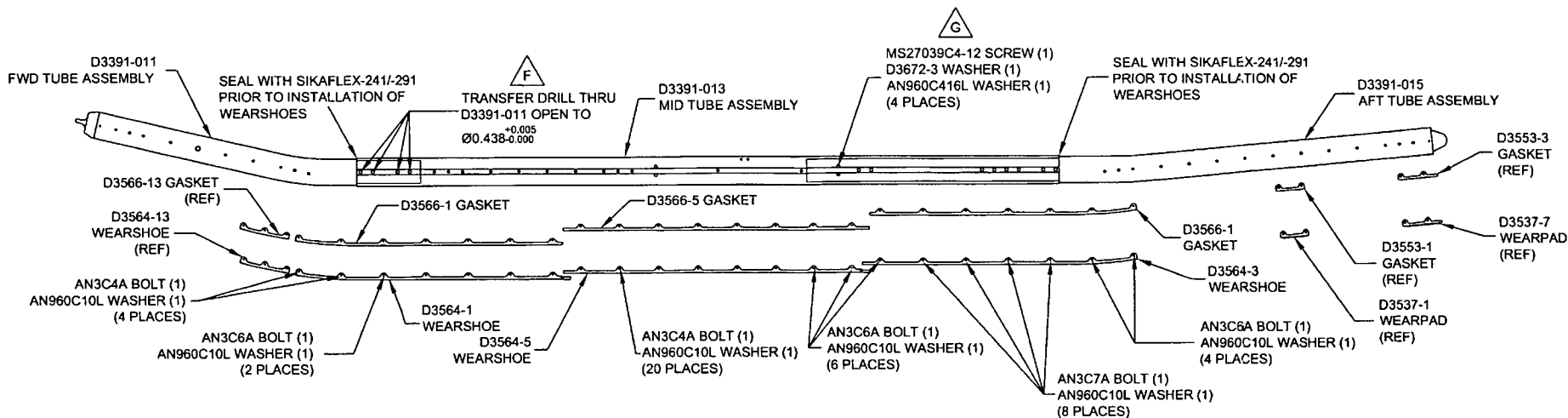
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries





**D3391-041 ASSEMBLY**

**RELEASED**  
27-11-06

**D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST**

| QTY | PART NUMBER  | DESCRIPTION             |
|-----|--------------|-------------------------|
| X   | D3391-041    | FLOAT SKIDTUBE ASSEMBLY |
| 1   | D3391-011    | FWD TUBE ASSEMBLY       |
| 1   | D3391-013    | MID TUBE ASSEMBLY       |
| 1   | D3391-015    | AFT TUBE ASSEMBLY       |
| 1   | D3564-1      | WEARSHOE                |
| 1   | D3564-3      | WEARSHOE                |
| 1   | D3564-5      | WEARSHOE                |
| 2   | D3566-1      | GASKET                  |
| 1   | D3566-5      | GASKET                  |
| 4   | D3672-3      | WASHER                  |
| 24  | AN3C4A       | BOLT                    |
| 12  | AN3C6A       | BOLT                    |
| 8   | AN3C7A       | BOLT                    |
| 44  | AN960C10L    | WASHER                  |
| 4   | MS27039C4-12 | SCREW                   |
| 4   | AN960C416L   | WASHER                  |

**GENERAL NOTES**

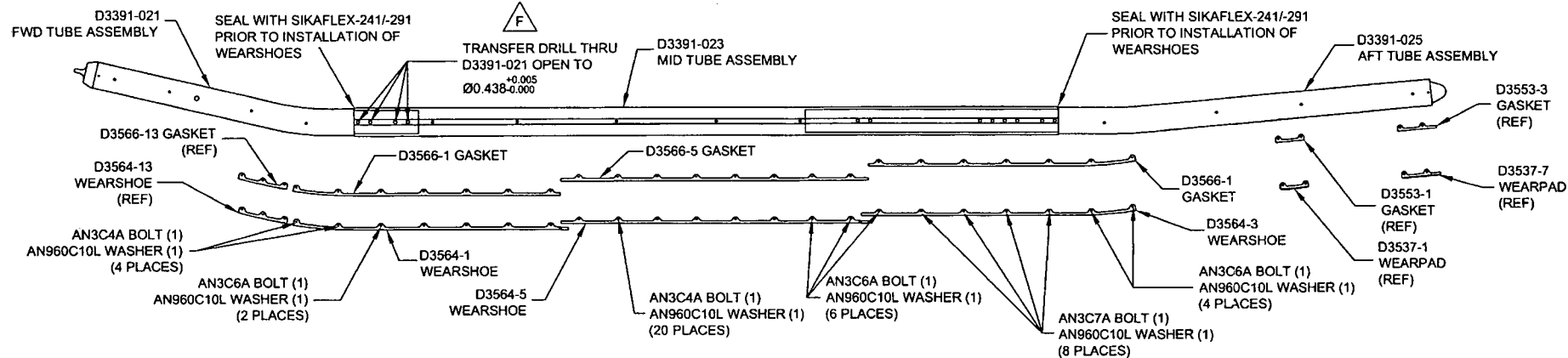
- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL 0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.

NO. 35762  
WORK ORDER  
SUBJECT TO AMENDMENT  
UNCONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHOP COPY

|   |   |    |          |
|---|---|----|----------|
| G | REPLACE NAS INSERTS W/ AELS INSERTS<br>SWITCH TO D3670-XXXX SPACERS FOR INSTALLING<br>FLOAT BAGS, DWG REORGANIZED FOR CLARITY | DC | 07.07.31 |
| F | ADD SS WEARSHOE, GASKET<br>REMOVE FWJ SADDLE HOLE -011/-021   | PH | 07.01.18 |
| E | CHANGE TOLERANCE, EASE MANUFACTURE  | PH | 06.04.25 |
| D | UPDATE TOLERANCE, CHANGE HOLE SIZE  | PH | 06.01.23 |
| C | LENGTHEN AFT EXTENSION  | PH | 05.09.27 |
| B | DRAWING UPDATES   | PH | 05.06.10 |
| A | NEW ISSUE   | PH | 05.02.07 |

| REV.       | DESCRIPTION | BY | DATE |
|------------|-------------|----|------|
| DESIGN     |             | PH |      |
| DRAWN      |             | PH |      |
| CHECKED    |             | PH |      |
| MFG. APPR. |             | PH |      |
| APPROVED   |             | PH |      |
| DE APPR.   |             | PH |      |
| DATE       | 07.07.31    |    |      |

|  |                        |
|--|------------------------|
| <b>DART AEROSPACE USA, INC</b><br>PORT HADLOCK, WA   |                        |
| DRAWING NO.<br>D3391   | REV. G<br>SHEET 1 OF 8 |
| TITLE<br>412 FLOAT SKIDTUBE  | SCALE<br>NTS           |
| COPYRIGHT © 2005 BY DART AEROSPACE USA, INC<br>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS<br>NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT<br>WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. |                        |



**D3391-043 ASSEMBLY**

**RELEASED**  
07.11.94

**D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST**

| QTY | PART NUMBER | DESCRIPTION             |
|-----|-------------|-------------------------|
| X   | D3391-043   | FLOAT SKIDTUBE ASSEMBLY |
| 1   | D3391-021   | FWD TUBE ASSEMBLY       |
| 1   | D3391-023   | MID TUBE ASSEMBLY       |
| 1   | D3391-025   | AFT TUBE ASSEMBLY       |
| 1   | D3564-1     | WEARSHOE                |
| 1   | D3564-3     | WEARSHOE                |
| 1   | D3564-5     | WEARSHOE                |
| 2   | D3566-1     | GASKET                  |
| 1   | D3566-5     | GASKET                  |
| 24  | AN3C4A      | BOLT                    |
| 12  | AN3C6A      | BOLT                    |
| 8   | AN3C7A      | BOLT                    |
| 44  | AN960C10L   | WASHER                  |

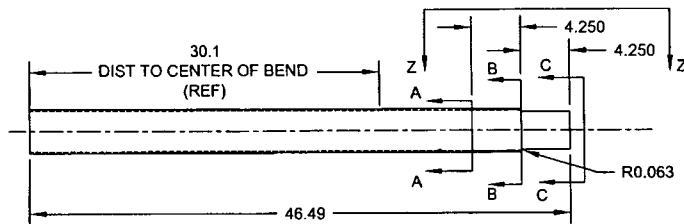
**GENERAL NOTES**

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.

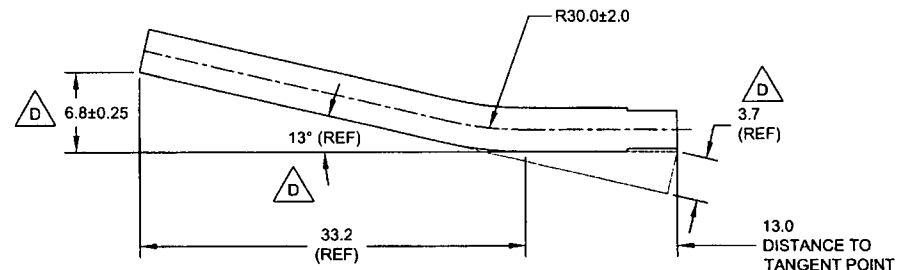
|            |          |   |
|------------|----------|---|
| DESIGN     | PH       | <b>DART AEROSPACE USA, INC</b>              |
| DRAWN      | JFC      | PORT HADLOCK, WA                            |
| CHECKED    | JFC      | DRAWING NO. REV. G                          |
| MFG. APPR. | JFC      | D3391 SHEET 2 OF 8                          |
| APPROVED   | JFC      | TITLE SCALE                                 |
| DE APPR.   | JFC      | 412 FLOAT SKIDTUBE NTS                      |
| DATE       | 07.07.31 | COPYRIGHT © 2005 BY DART AEROSPACE USA, INC |

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

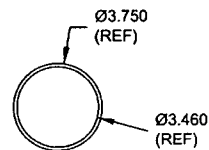
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 35762



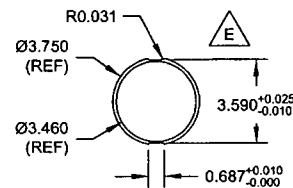
**D3391-1 CUTTING DETAIL**  
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



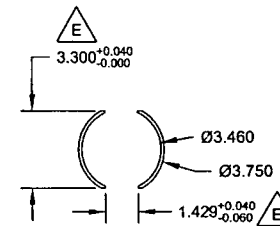
**D3391-011/-021 BENDING DETAIL**  
(MAKE FROM D3391-1)



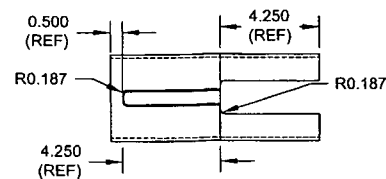
**SECTION A-A**  
(SCALE 1:5)



**SECTION B-B**  
(SCALE 1:5)



**SECTION C-C**  
(SCALE 1:5)



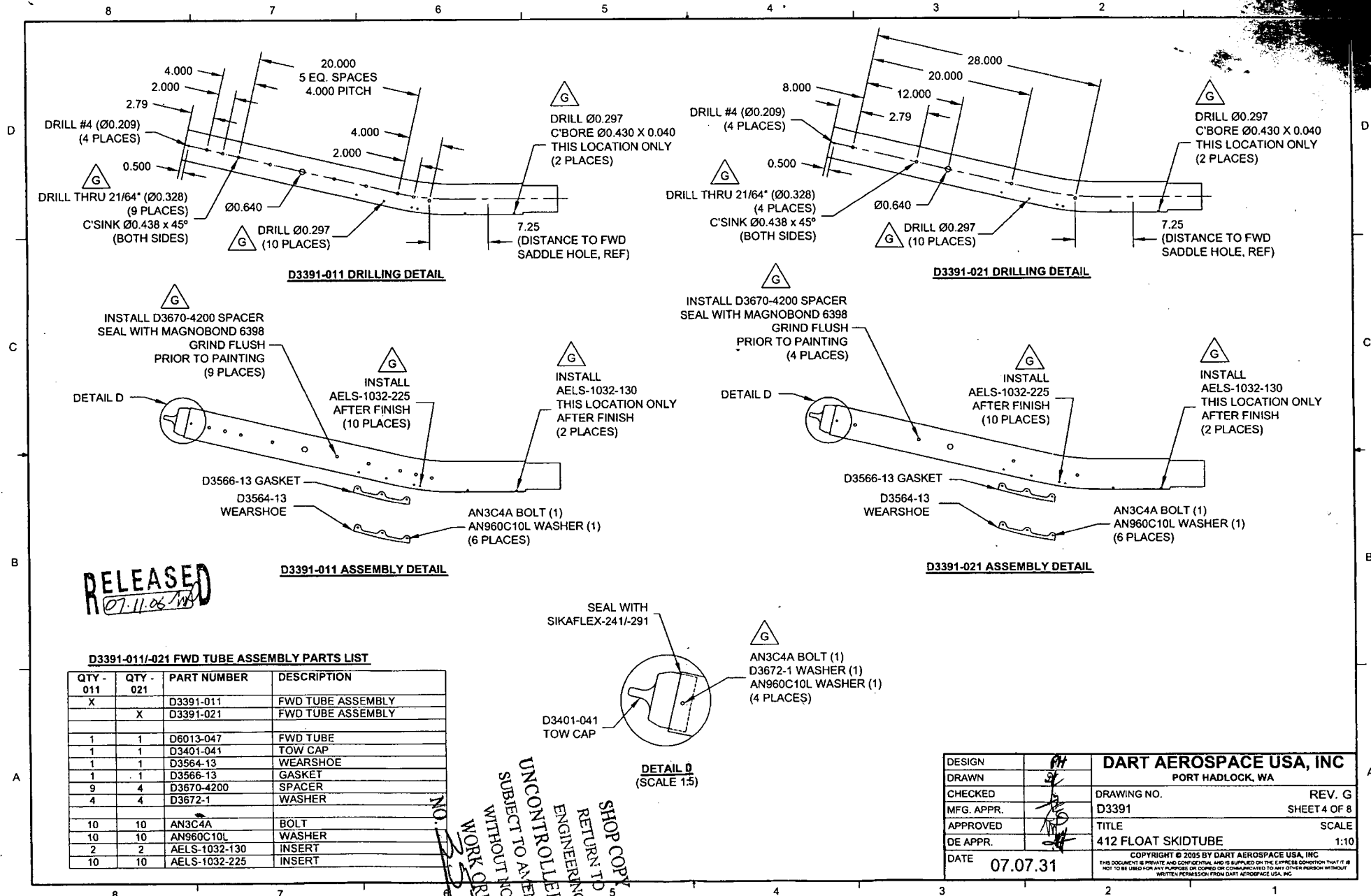
**VIEW Z-Z**  
(SCALE 1:5)

RELEASED  
07-11-08

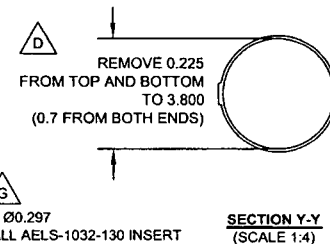
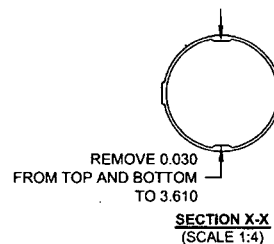
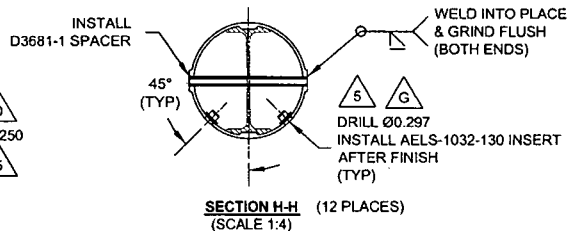
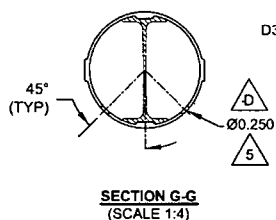
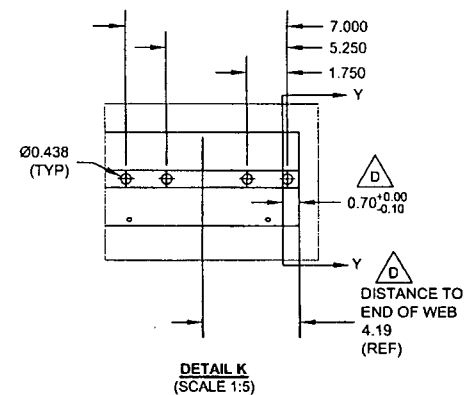
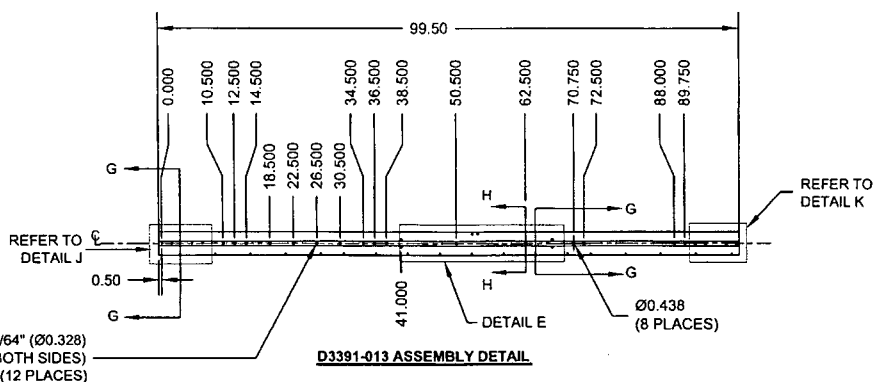
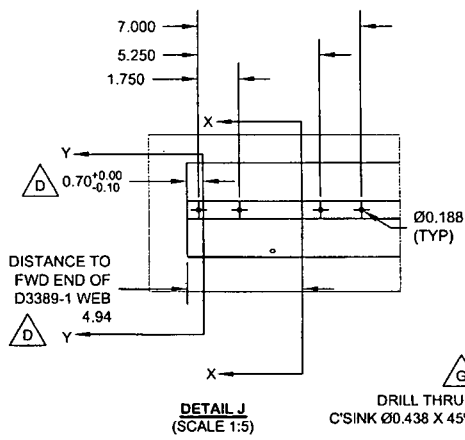
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
NO. 35762  
WORK ORDER

|   |          |  |              |
|---|----------|--|--------------|
| DESIGN  |          | <b>DART AEROSPACE USA, INC</b>               |              |
| DRAWN   | JHC      | PORT HADLOCK, WA                             |              |
| CHECKED   | JHC      | DRAWING NO.                                  | REV. G       |
| MFG. APPR.  | JHC      | D3391  | SHEET 3 OF 8 |
| APPROVED  | JHC      | TITLE  | SCALE        |
| DE APPR.  | JHC      | 412 FLOAT SKIDTUBE                           | 1:10         |
| DATE  | 07.07.31 | COPYRIGHT © 2005 BY DART AEROSPACE USA, INC. |              |
| THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. |          |  |              |



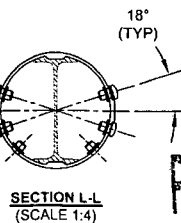
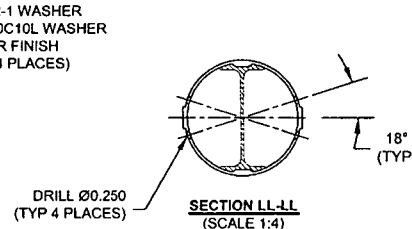
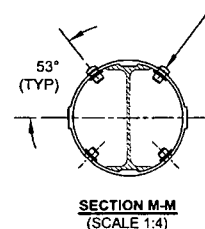
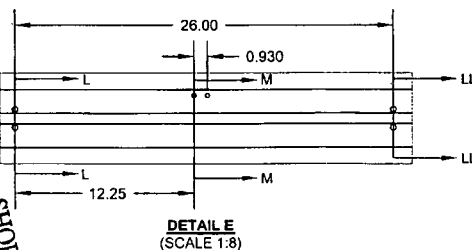






#### D3391-013 MID TUBE ASSEMBLY PARTS LIST

| QTY | PART NUMBER   | DESCRIPTION       |
|-----|---------------|-------------------|
| X   | D3391-013     | MID TUBE ASSEMBLY |
| 1   | D2500-1-100   | EXTRUSION         |
| 1   | D3389-1       | WEB               |
| 12  | D3681-1       | SPACER            |
| 4   | D3672-1       | WASHER            |
| 4   | D3672-3       | WASHER            |
| 24  | AELS-1032-130 | INSERT            |
| 4   | ALS4-428-165  | INSERT            |
| 4   | AN960C10L     | WASHER            |
| 4   | AN960C416L    | WASHER            |
| 4   | MS27039C1-09  | SCREW             |
| 4   | MS27039C4-08  | SCREW             |



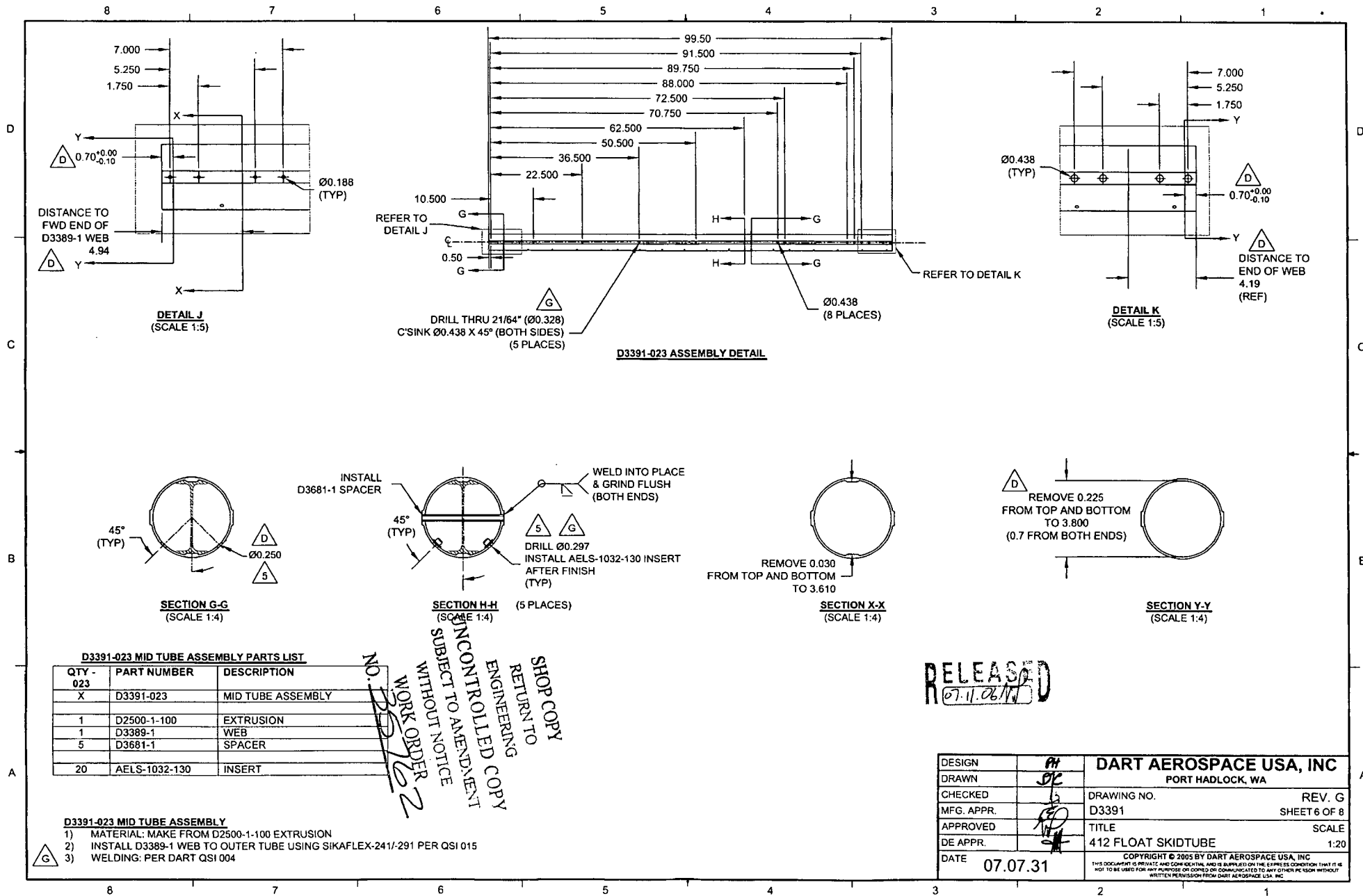
#### D3391-013 MID TUBE ASSEMBLY

- MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- WELDING: PER DART QSI 004

|            |          |   |              |
|------------|----------|---|--------------|
| DESIGN     | PH       | <b>DART AEROSPACE USA, INC</b>              |              |
| DRAWN      | DP       | PORT HADLOCK, WA                            |              |
| CHECKED    | DP       | DRAWING NO.                                 | REV. G       |
| MFG. APPR. | DP       | D3391                                       | SHEET 5 OF 8 |
| APPROVED   | DP       | TITLE                                       | SCALE        |
| DE APPR.   | DP       | 412 FLOAT SKIDTUBE                          | 1:20         |
| DATE       | 07.07.31 | COPYRIGHT © 2005 BY DART AEROSPACE USA, INC |              |

RELEASED  
07.11.06

UNCONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHOP COPY  
NO. 251122  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER



**D3391-023 MID TUBE ASSEMBLY PARTS LIST**

| QTY - 023 | PART NUMBER   | DESCRIPTION       |
|-----------|---------------|-------------------|
| X         | D3391-023     | MID TUBE ASSEMBLY |
| 1         | D2500-1-100   | EXTRUSION         |
| 1         | D3389-1       | WEB               |
| 5         | D3681-1       | SPACER            |
| 20        | AELS-1032-130 | INSERT            |

- D3391-023 MID TUBE ASSEMBLY**
- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
  - 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
  - 3) WELDING: PER DART QSI 004

RELEASED  
07-11-06/11

|            |          |   |        |
|------------|----------|---|--------|
| DESIGN     | PH       | <b>DART AEROSPACE USA, INC</b>  |        |
| DRAWN      | DC       | PORT HADLOCK, WA  |        |
| CHECKED    | LS       | DRAWING NO. D3391   | REV. G |
| MFG. APPR. | FD       | SHEET 6 OF 8  |        |
| APPROVED   | SH       | TITLE   | SCALE  |
| DE APPR.   |          | 412 FLOAT SKIDTUBE  | 1:20   |
| DATE       | 07.07.31 | <small>COPYRIGHT © 2005 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small> |        |

NO. 20762  
 WORK ORDER  
 WITHOUT NOTICE  
 SUBJECT TO AMENDMENT  
 UNCONTROLLED COPY  
 ENGINEERING  
 RETURN TO  
 SHOP COPY

